

**Work Order ID 59847**

Monday, June 14, 2010 2:31:39 PM



Page 1

Item ID: D3838-042

Accept



Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 18Date: 10-6-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: 111679

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: 111679

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

② CP 10-06-30S40 10-06-18

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Page 2

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/2010

12

-042

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.07.01

130

Identify as per dwg & Stock Location: *Basket*

0.00



Packaging

Memo

0.00

Packaging

PD 10.07.01



**Work Order ID 59847**


Monday, June 14, 2010 2:31:39 PM

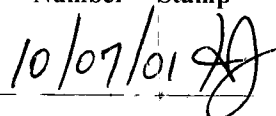


Page 3

Item ID: D3838-042 Accept  Setup Start   
Revision ID:  
Item Name: Rib Assembly (Basket Lid, RH) Stop   
Start Date: 6/14/2010 Start Qty: 2.00  Cust Item ID:  
Required Date: 6/18/2010 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/07/01   
mf  
10-7-0

# Picklist Print

Monday, June 14, 2010 2:31:43 PM

Page 1

Work Order ID: 59847

Parent Item: D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 6/14/2010


Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1  Bushing		Manufactured	No			100	Each	16.0000	1	2			
---	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	16	
54072	9	
58672	7	

M304TS0.750W.065  304 SQ Tube .75x.75x.065W		Purchased	No			100	f	938.4760	1.0317	2.172			
--	--	-----------	----	--	--	-----	---	----------	--------	-------	--	--	--

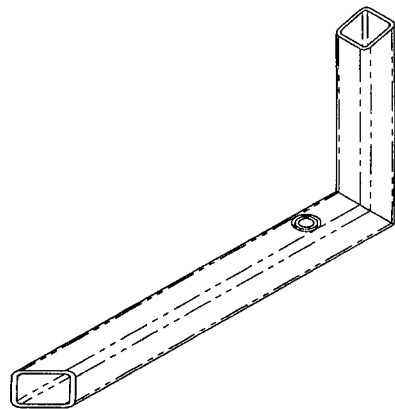
Location	Loc Qty	Loc Code
MAT	53.32232	
112398	0	
114482	53.32232	
WA	885.1537	
114520	885.1537	

*CP 10-06-30*

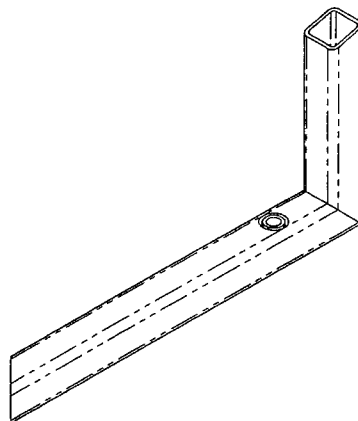
*B59644 → (2)*

*SA 10-06-28*

*2.172*



**D3838-041 RIB ASSY (BASKET LID, LH)**



**D3838-042 RIB ASSY (BASKET LID, RH)**

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39847  
*20-0-6-14*

**RELEASED**  
*08/10/08*

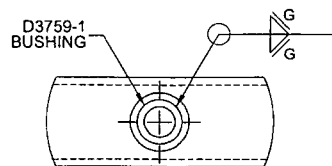
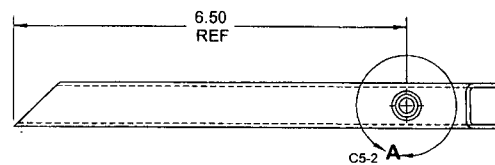
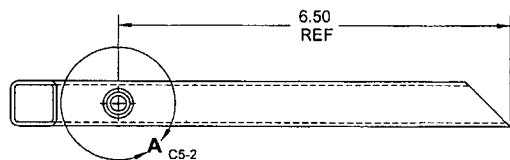
- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

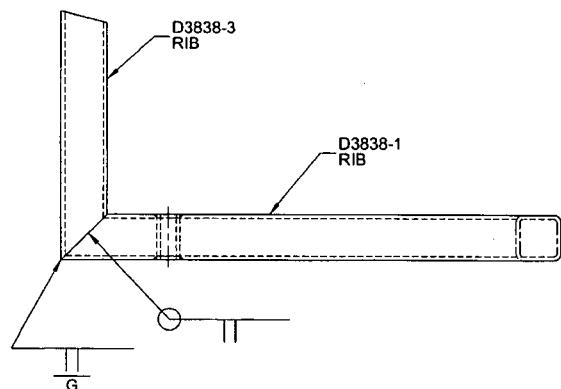
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A  
TITLE **RIB ASSY (BASKET LID)** SCALE NTS  
SHEET 1 OF 3

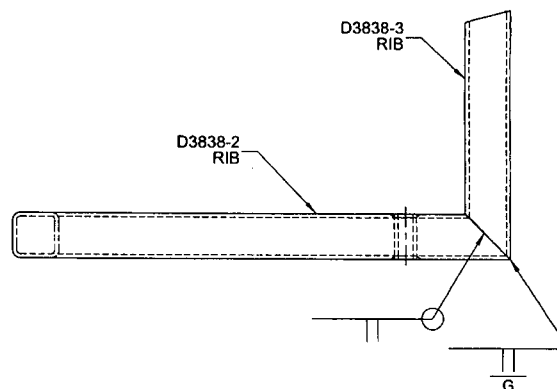
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**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-041 RIB ASSY (BASKET LID, LH)**



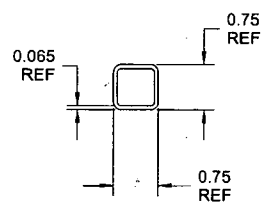
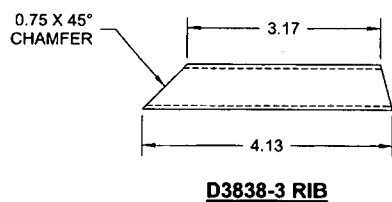
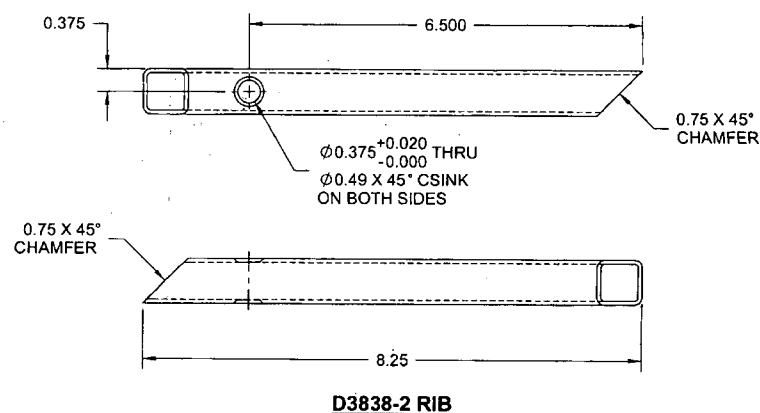
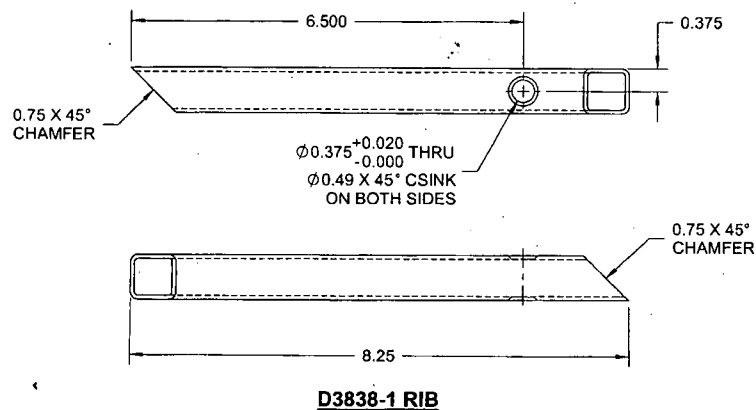
**D3838-042 RIB ASSY (BASKET LID, LH)**

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08/10/08

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE <b>RIB ASSY (BASKET LID)</b>	SCALE NTS
DE APPR.			
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8 7 6 5 4 3 2 1

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**TYPICAL SECTION VIEW**

wb 35847

**RELEASED**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1